

87654321

ITEM #	QTY	PART #	PART TITLE
-1	1	RBW7110G00131-8G-1	FRAME WELDMENT
-6	2	RBW7110G00131-8G-6	CABLE END
-7	2	RBW7110G00131-8G-7	DISK
-8	2	RBW7110G00131-8G-8	KNOB
-9	1	RBW7110G00131-8G-9	TUBE
-10	3	RBW7110G00131-8G-10	JACKET ASSEMBLY
16	1	RB41011	DART PLACARD
17	A/R	CARR-LANE#CL-2-C	NYLON COATED STEEL LANYARD 1/16" DIA.
18	1	McMaster#3293T43 OR EQUIV.	ALUMINUM SCREW LOCKING CARABINER 7/16" THK. X 1600 LBS. CAPACITY
19	3	McMaster#3550T34 OR EQUIV.	STEEL WIRE ROPE SLING 1/4" DIA. X 3' LG.
20	1	McMaster#3555T47 OR EQUIV.	GALVANIZED STEEL SAFETY PIN SHACKLE 13/32" PIN DIA. X 1600 LBS. CAPACITY
21	1	McMaster#3568T42 OR EQUIV.	GRADE 80 STEEL OBLING LINK 5" LG. X 2-1/2" WD. X 1/2" THK. X 4100 LBS. CAPACITY
22	2	McMaster#3896T31 OR EQUIV.	ALUMINUM WIRE ROPE COMPRESSION SLEEVE 1/16" DIA. X 3/8" LG.
23	4	McMaster#8494T13 OR EQUIV.	BLACK OXIDE STEEL SCREW PIN SHACKLE 3/8" PIN DIA. X 1500 LBS. CAPACITY.
24	4	McMaster#90081A077 OR EQUIV.	ZINC PLATED STEEL SCREW NAIL #2 SIZE X 1/4" LG.
25	2	McMaster#93298A125 OR EQUIV.	ZINC PLATED GRADE F STEEL NYLON-INSERT FLANGE LOCKNUT 5/16"-24 X 11/32" HEIGHT.
26	4	McMaster#98023A030 OR EQUIV.	YELLOW ZINC PLATED GRADE 8 STEEL WASHER 0.344" ID X 0.688" OD. X 0.051"-0.080" THK.
27	2	AN5-6A	BOLT

19-611

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RELEASED FOR PRODUCTION

ECN #

BY

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REV.

DESCRIPTION

ECN #

BY

DESIGN

DRAWN

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MFG. APPR.

APPROVED

DATE

2/27/2019

KPT

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DART AEROSPACE LTD

HAWKESBURY, ONTARIO, CANADA

TOOL PART #

RBW7110G00131-8G

TITLE

REAR SLIDING COWLING LIFTING SLING TOOL

SCALE

NTS

REV. B

SHEET 1 OF 18

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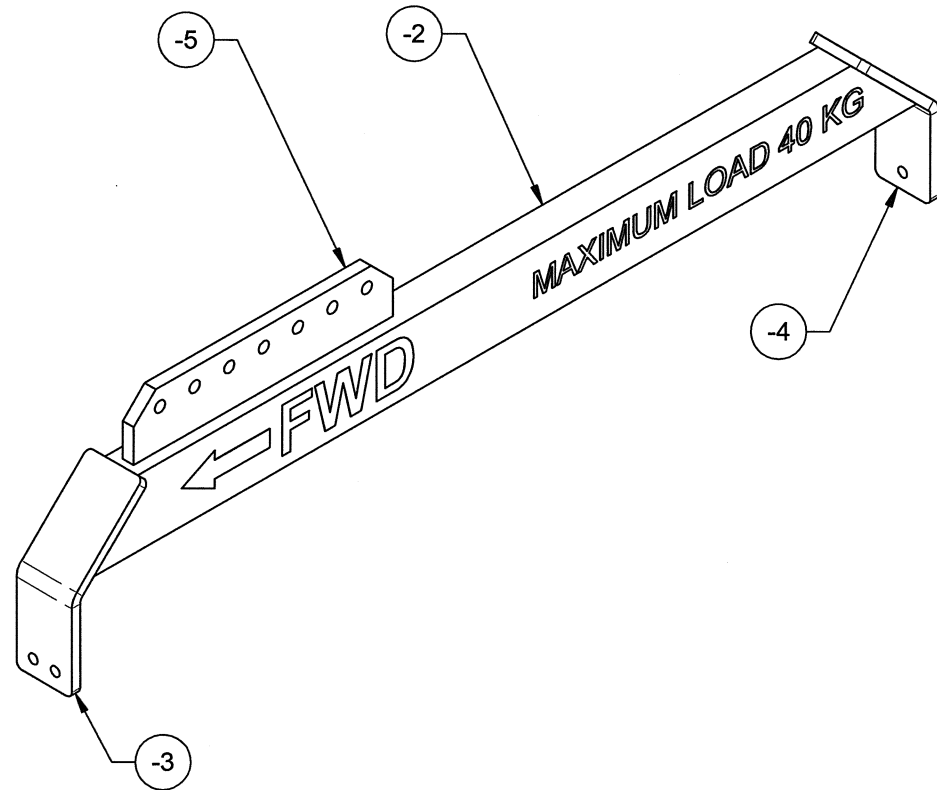
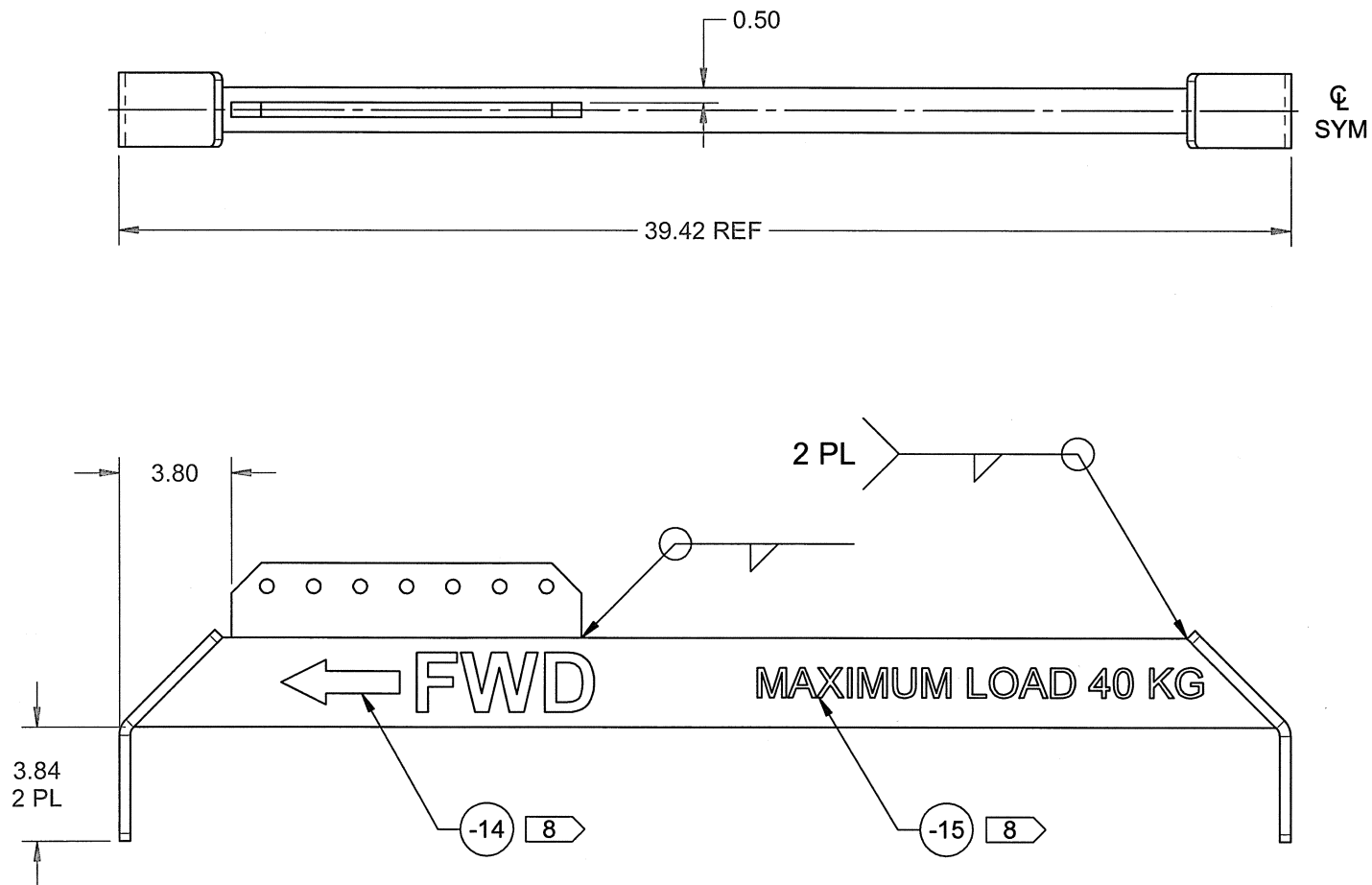
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RBW7110G00131-8G REAR SLIDING COWLING LIFTING SLING TOOL

NOTES:  
1) MATERIAL: N/A  
2) HEAT TREAT: N/A  
3) FINISH: N/A  
4) TOLERANCES: X.X = +/- 0.1" / +/- 1°  
X.XX = +/- 0.01" / +/- 0.5°  
X.XXX = +/- 0.005" / +/- 0.1°  
X.XXXX = +/- 0.0005" / +/- 0.05°  
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"  
5) UNITS: INCHES UNLESS OTHERWISE NOTED  
6) IDENTIFICATION: ENGRAVE THE TOOL P/N, S/N, AND "SWL: 40 KG / 90 LBS" ON THE DART PLACARD WHERE INDICATED  
7) ASSEMBLE AS SHOWN  
8) ASSEMBLED LANYARD LENGTH MUST BE 6" +/- 1"  
9) INSTALL ITEM -8 HAND TIGHT  
10) TORQUE ITEM 25 TO 5-7 FT-LBS (60-85 IN-LBS)  
11) CENTER ITEM -10 ONTO ITEM 19



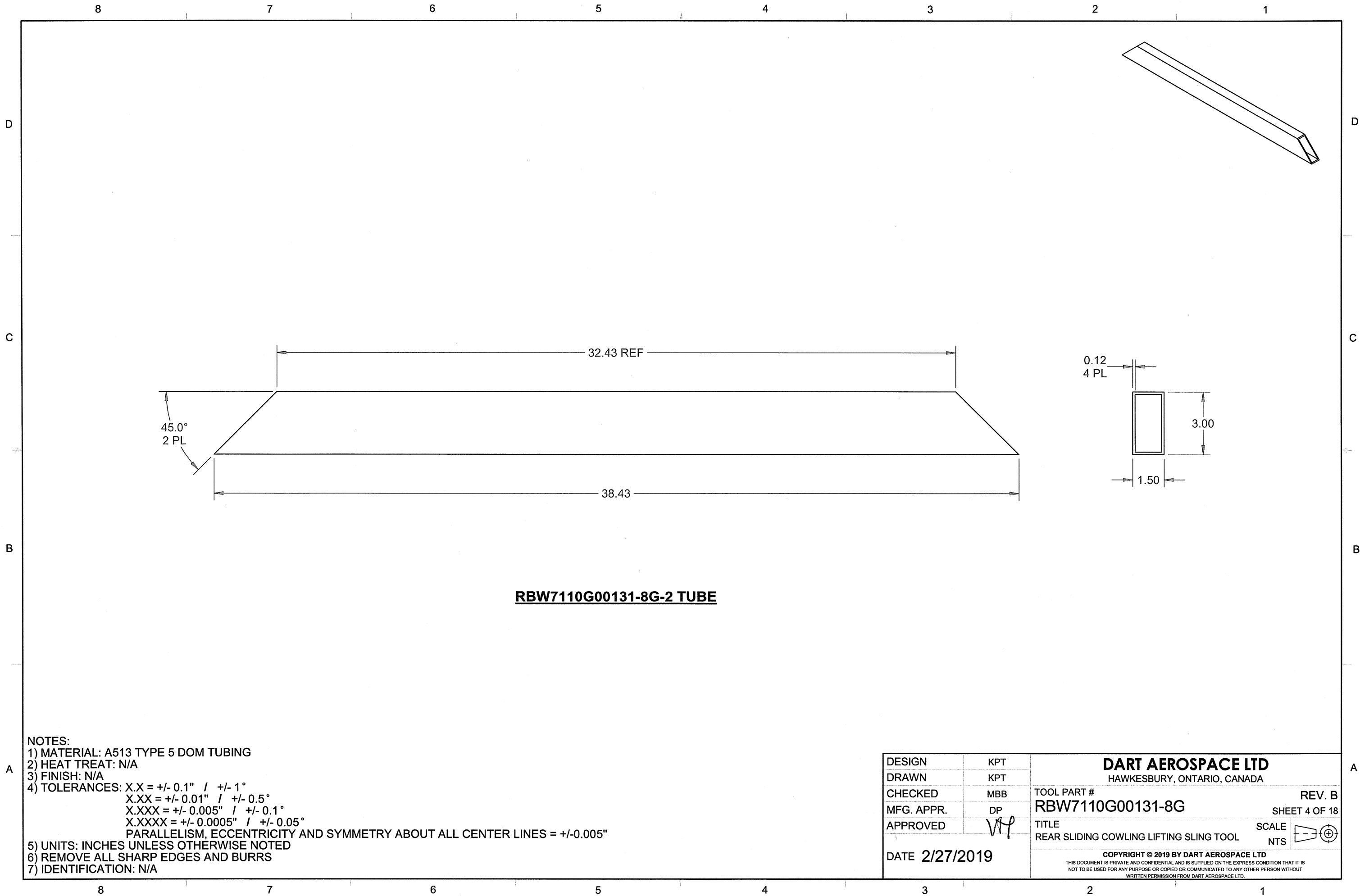
ITEM #	QTY	PART #	PART TITLE
-2	1	RBW7110G00131-8G-2	TUBE
-3	1	RBW7110G00131-8G-3	END CAP DOUBLE LEG
-4	1	RBW7110G00131-8G-4	END CAP SINGLE LEG
-5	1	RBW7110G00131-8G-5	SLING PLATE
-14	1	RBW7110G00131-8G-14	FWD STICKER
-15	1	RBW7110G00131-8G-15	MAX LOAD STICKER



**RBW7110G00131-8G-1 FRAME WELDMENT**

NOTES:  
1) MATERIAL: N/A  
2) HEAT TREAT: N/A  
3) FINISH: POWDERCOAT YELLOW QSI 005 OR MIL-PRF-24712  
4) TOLERANCES: X.X = +/- 0.1" / +/- 1°  
X.XX = +/- 0.01" / +/- 0.5°  
X.XXX = +/- 0.005" / +/- 0.1°  
X.XXXX = +/- 0.0005" / +/- 0.05°  
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"  
5) UNITS: INCHES UNLESS OTHERWISE NOTED  
6) REMOVE ALL WELD SPATTERS  
7) IDENTIFICATION: N/A  
8) POWDERCOAT BEFORE INSTALLING ITEMS -14 AND -15 APPROXIMATELY AS SHOWN

DESIGN	KPT	<b>DART AEROSPACE LTD</b>	
DRAWN	KPT	HAWKESBURY, ONTARIO, CANADA	
CHECKED	MBB	TOOL PART #	REV. B
MFG. APPR.	DP	RBW7110G00131-8G	SHEET 3 OF 18
APPROVED	VJP	TITLE	SCALE
		REAR SLIDING COWLING LIFTING SLING TOOL	NTS
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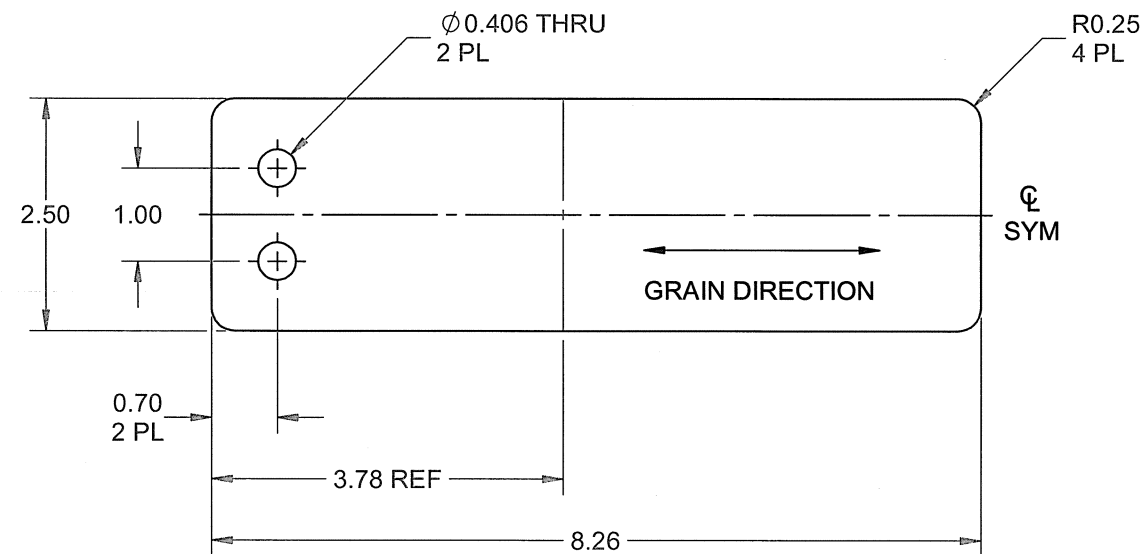
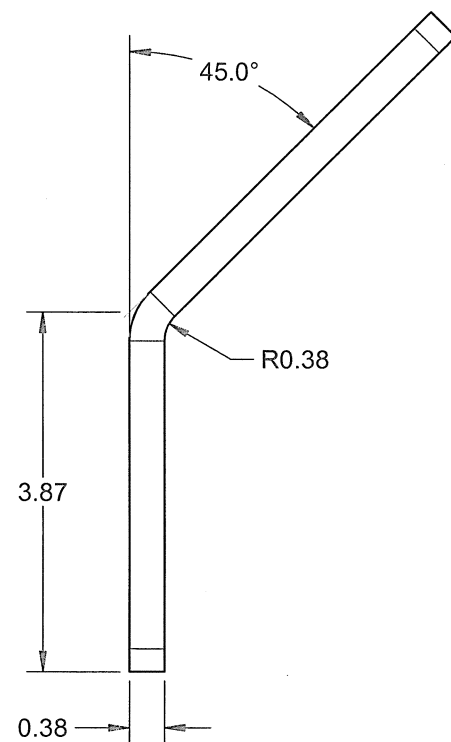
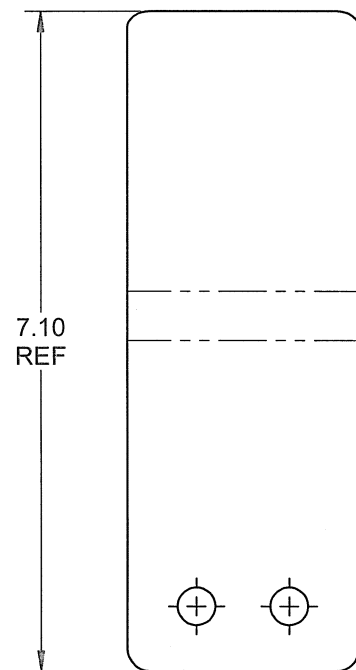
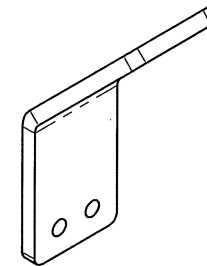
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**FLAT PATTERN****RBW7110G00131-8G-3 END CAP DOUBLE LEG****NOTES:**

1) MATERIAL: 1018/1020/1025 CR

2) HEAT TREAT: N/A

3) FINISH: N/A

4) TOLERANCES: X.X = +/- 0.1" / +/- 1°

X.XX = +/- 0.01" / +/- 0.5°

X.XXX = +/- 0.005" / +/- 0.1°

X.XXXX = +/- 0.0005" / +/- 0.05°

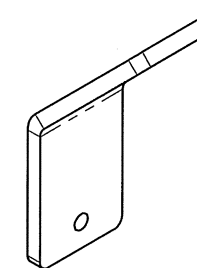
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"

5) UNITS: INCHES UNLESS OTHERWISE NOTED

6) REMOVE ALL SHARP EDGES AND BURRS

7) IDENTIFICATION: N/A


DESIGN	KPT	<b>DART AEROSPACE LTD</b>	
DRAWN	KPT	HAWKESBURY, ONTARIO, CANADA	
CHECKED	MBB	TOOL PART #	REV. B
MFG. APPR.	DP	<b>RBW7110G00131-8G</b>	SHEET 5 OF 18
APPROVED	VMP	TITLE	SCALE
		REAR SLIDING COWLING LIFTING SLING TOOL	NTS
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## FLAT PATTERN

NOTES:

- 1) MATERIAL: 1018/1020/1025 CR
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°  
X.XX = +/- 0.01" / +/- 0.5°  
X.XXX = +/- 0.005" / +/- 0.1°  
X.XXXX = +/- 0.0005" / +/- 0.05°  
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) REMOVE ALL SHARP EDGES AND BURRS
- 7) IDENTIFICATION: N/A

DESIGN	KPT	<b>DART AEROSPACE LTD</b>	
DRAWN	KPT	HAWKESBURY, ONTARIO, CANADA	
CHECKED	MBB	TOOL PART #	REV. E
MFG. APPR.	DP	<b>RBW7110G00131-8G</b>	SHEET 6 OF 18
APPROVED	<i>Wp</i>	TITLE	SCALE
		REAR SLIDING COWLING LIFTING SLING TOOL	NTS 
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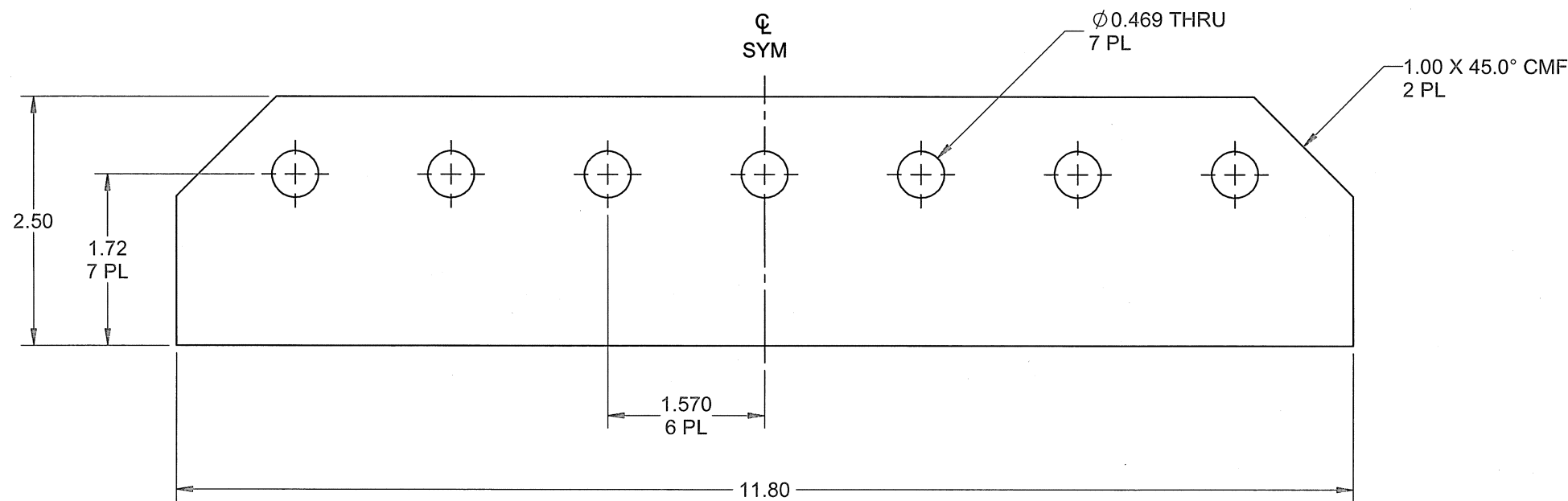
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**RBW7110G00131-8G-5 SLING PLATE****NOTES:**

1) MATERIAL: 1018/1020/1025 CR

2) HEAT TREAT: N/A

3) FINISH: N/A

4) TOLERANCES: X.X = +/- 0.1" / +/- 1°

X.XX = +/- 0.01" / +/- 0.5°

X.XXX = +/- 0.005" / +/- 0.1°

X.XXXX = +/- 0.0005" / +/- 0.05°

PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"

5) UNITS: INCHES UNLESS OTHERWISE NOTED

6) REMOVE ALL SHARP EDGES AND BURRS

7) IDENTIFICATION: N/A

DESIGN	KPT	<b>DART AEROSPACE LTD</b>	
DRAWN	KPT	HAWKESBURY, ONTARIO, CANADA	
CHECKED	MBB	TOOL PART #	REV. B
MFG. APPR.	DP	<b>RBW7110G00131-8G</b>	SHEET 7 OF 18
APPROVED	WT	TITLE	SCALE
		REAR SLIDING COWLING LIFTING SLING TOOL	NTS
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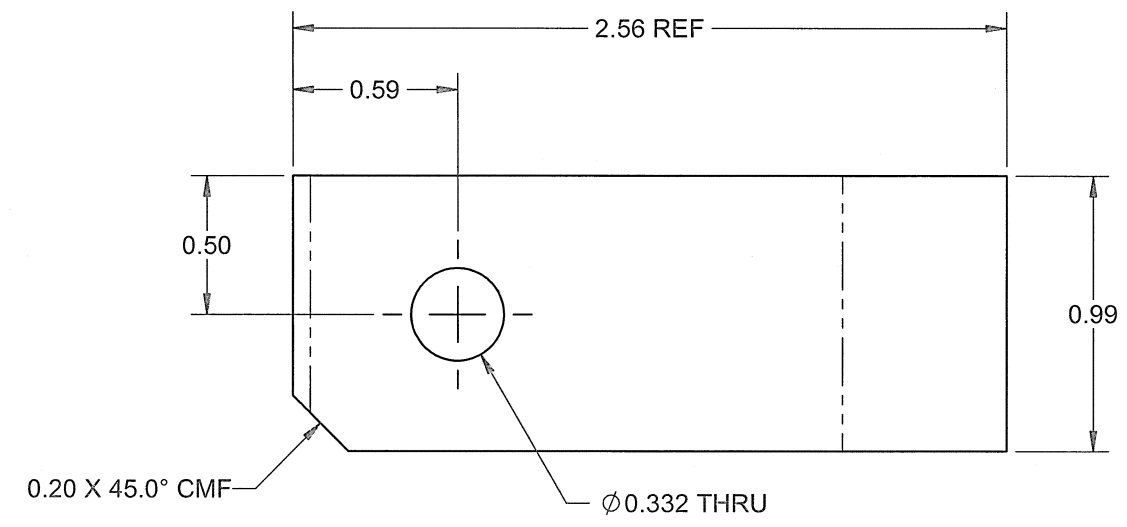
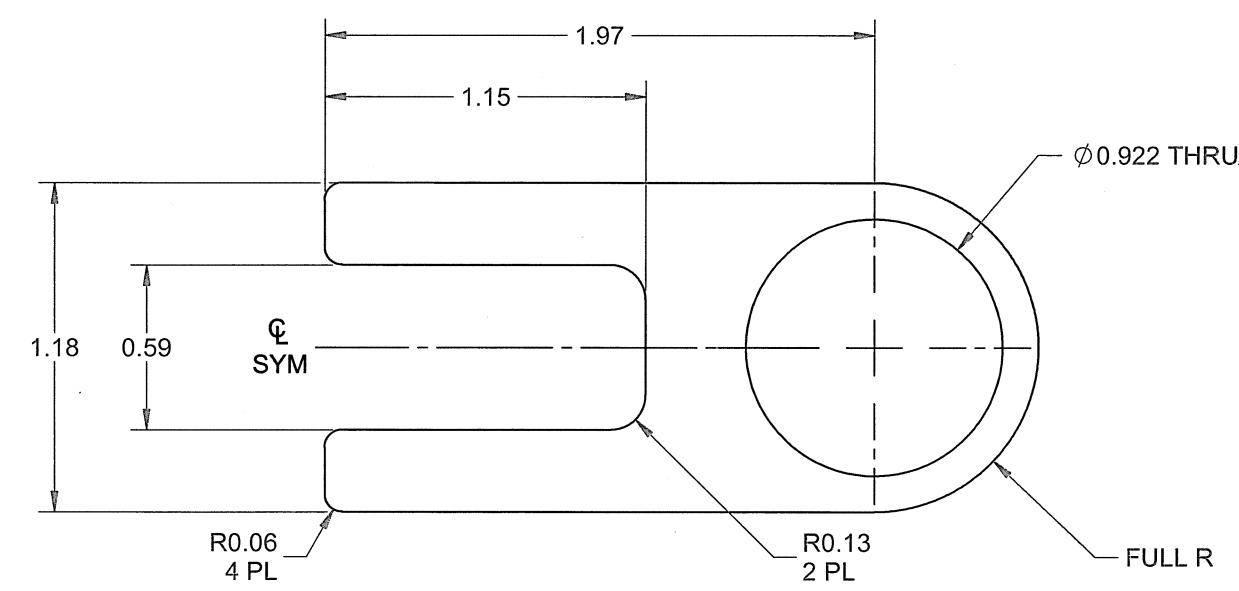
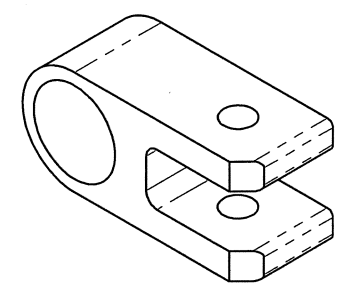
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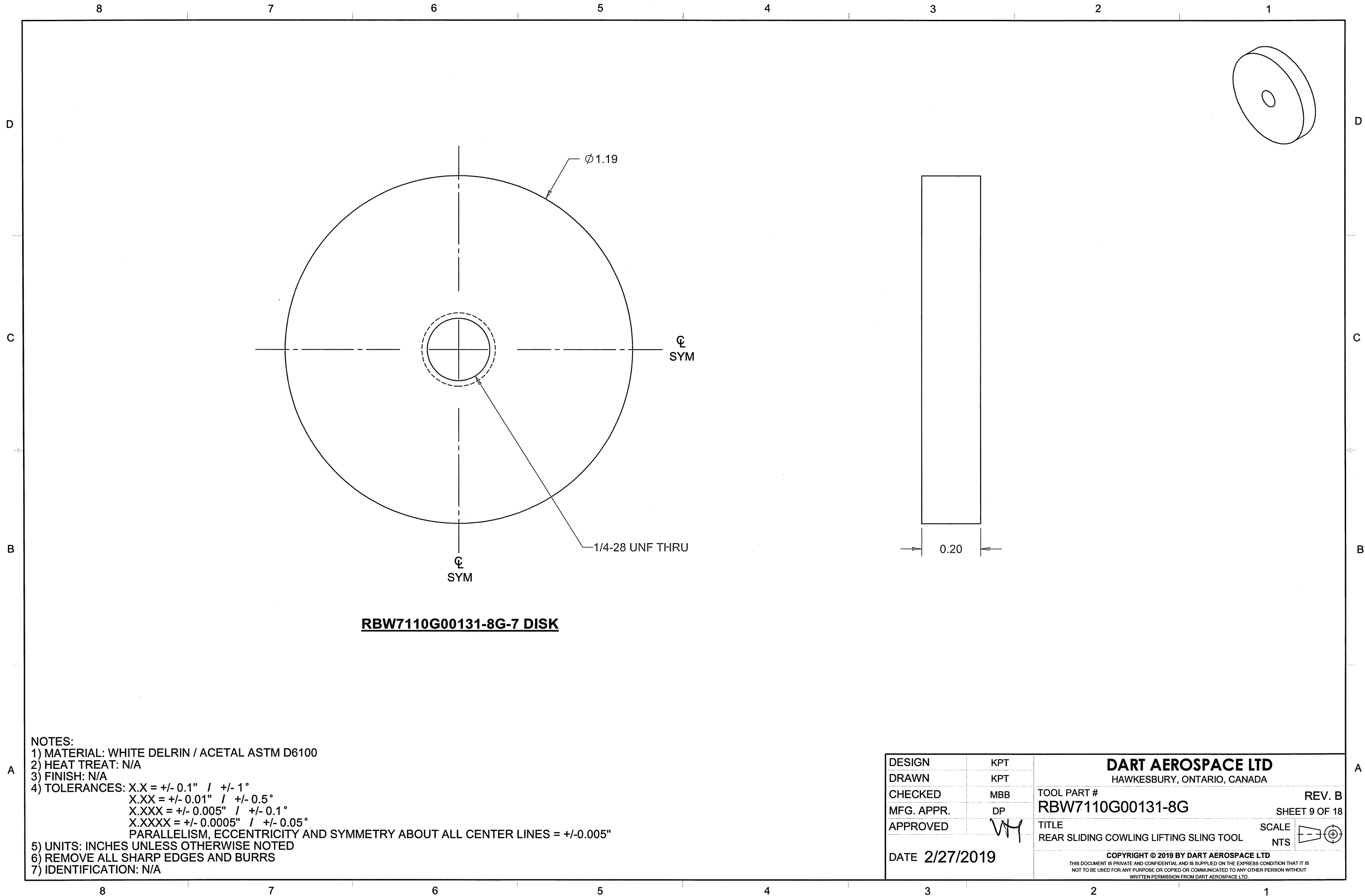


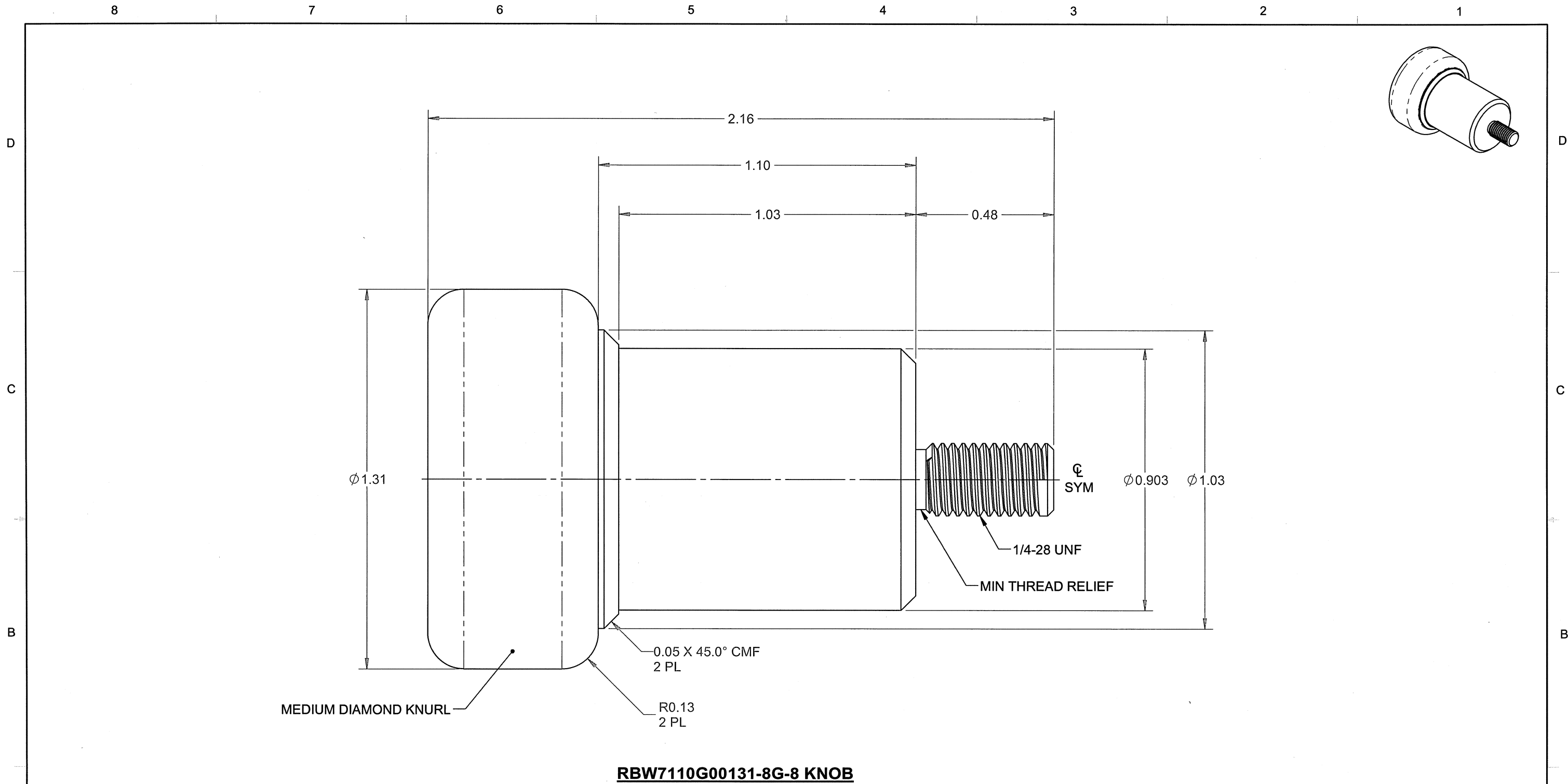
**RBW7110G00131-8G-6 CABLE END**

- NOTES:
- 1) MATERIAL: 6061-T6 / 7075-T6
  - 2) HEAT TREAT: N/A
  - 3) FINISH: ANODIZE RED PER MIL-A-8625 TYPE 2 CLASS 2
  - 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°  
X.XX = +/- 0.01" / +/- 0.5°  
X.XXX = +/- 0.005" / +/- 0.1°  
X.XXXX = +/- 0.0005" / +/- 0.05°  
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
  - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 6) REMOVE ALL SHARP EDGES AND BURRS
  - 7) IDENTIFICATION: N/A

DESIGN	KPT	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	KPT		
CHECKED	MBB	TOOL PART #	REV. B
MFG. APPR.	DP	RBW7110G00131-8G	SHEET 8 OF 18
APPROVED	WY	TITLE	SCALE
DATE 2/27/2019		REAR SLIDING COWLING LIFTING SLING TOOL	NTS
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NOTES:

1) MATERIAL: 303/304/316 STAINLESS STEEL

2) HEAT TREAT: N/A

3) FINISH: N/A

4) TOLERANCES: X.X = +/- 0.1" / +/- 1°

X.XX = +/- 0.01" / +/- 0.5°

X.XXX = +/- 0.005" / +/- 0.1°

X.XXXX = +/- 0.0005" / +/- 0.05°

PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"

5) UNITS: INCHES UNLESS OTHERWISE NOTED

6) REMOVE ALL SHARP EDGES AND BURRS

7) IDENTIFICATION: N/A

DESIGN	KPT	<b>DART AEROSPACE LTD</b>	
DRAWN	KPT	HAWKESBURY, ONTARIO, CANADA	
CHECKED	MBB	TOOL PART #	REV. B
MFG. APPR.	DP	<b>RBW7110G00131-8G</b>	SHEET 10 OF 18
APPROVED		TITLE	SCALE
DATE <b>2/27/2019</b>		REAR SLIDING COWLING LIFTING SLING TOOL	NTS
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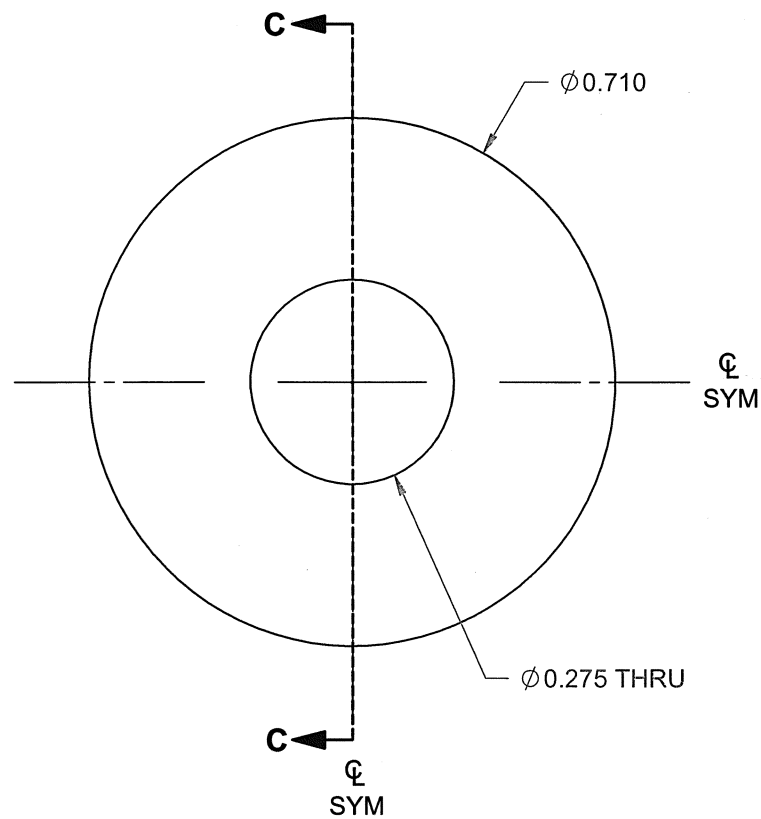
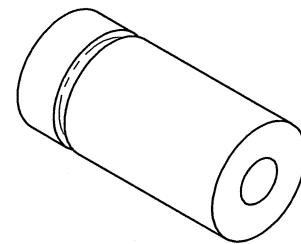
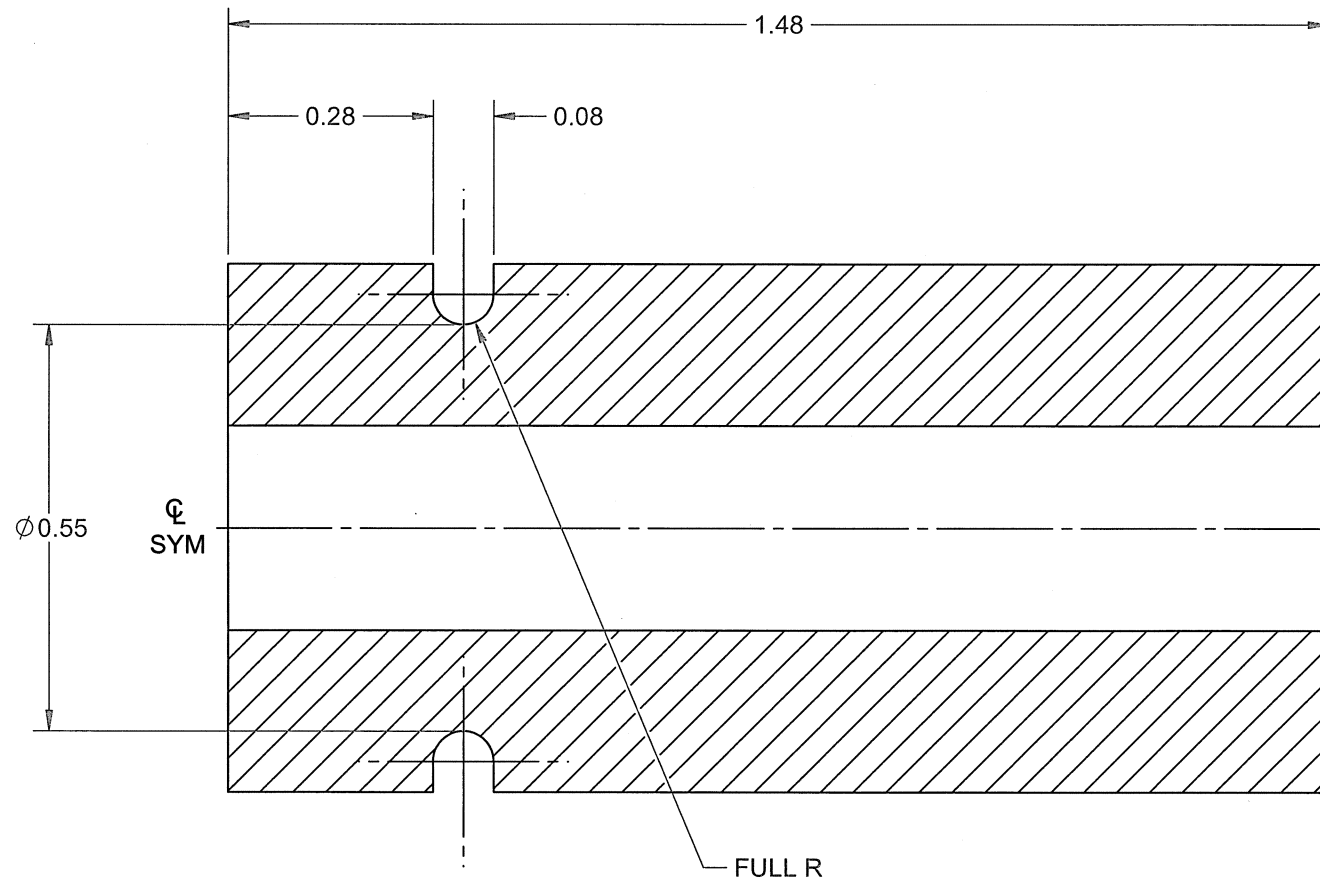
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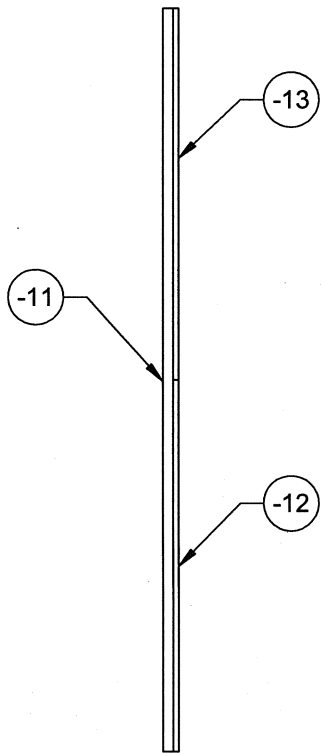
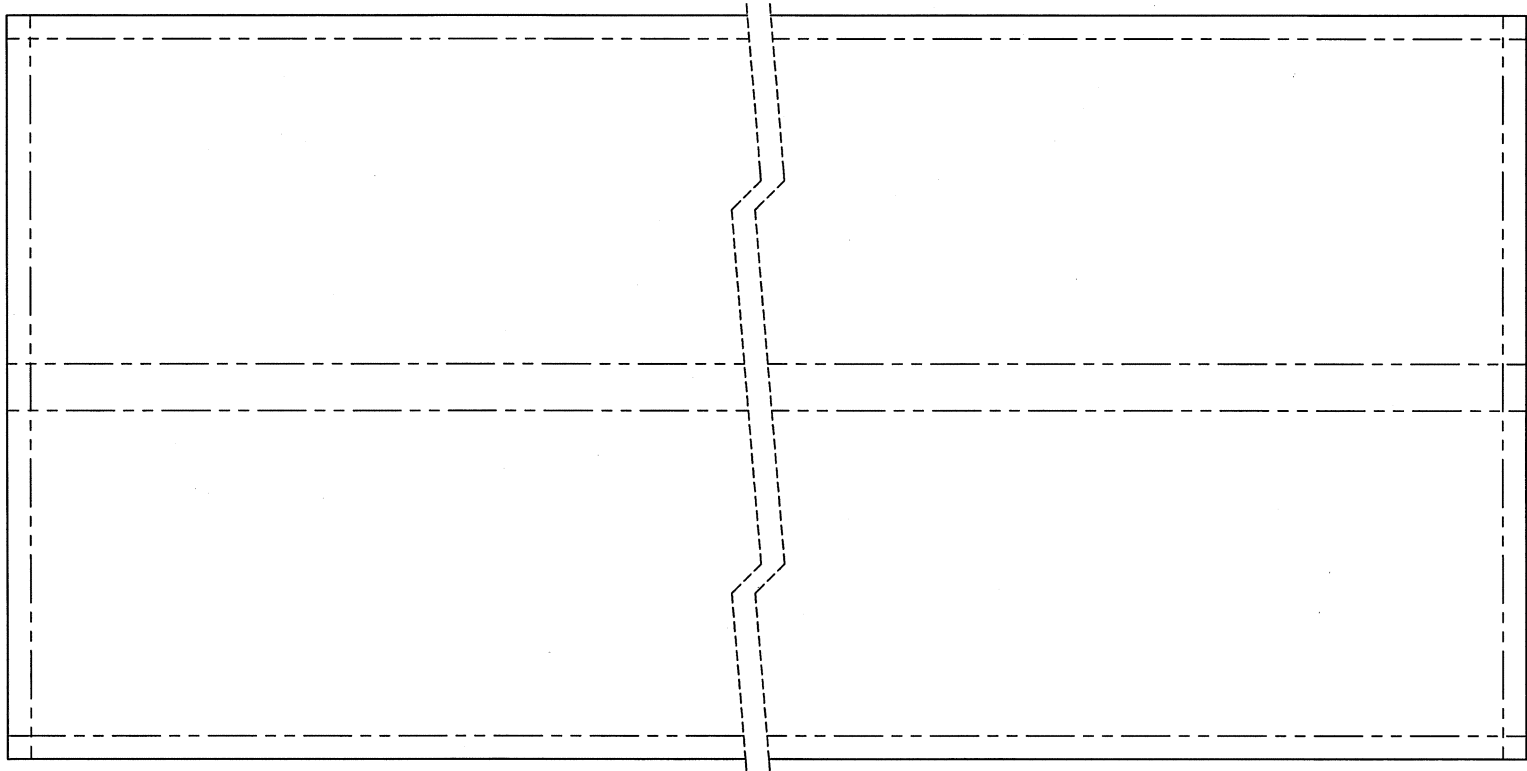
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**RBW7110G00131-8G-9 TUBE****SECTION C-C****NOTES:**

- 1) MATERIAL: 6061-T6 / 7075-T6
- 2) HEAT TREAT: N/A
- 3) FINISH: ANODIZE RED PER MIL-A-8625 TYPE 2 CLASS 2
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°  
X.XX = +/- 0.01" / +/- 0.5°  
X.XXX = +/- 0.005" / +/- 0.1°  
X.XXXX = +/- 0.0005" / +/- 0.05°  
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) REMOVE ALL SHARP EDGES AND BURRS
- 7) IDENTIFICATION: N/A

DESIGN	KPT	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	KPT		
CHECKED	MBB	TOOL PART #	REV. B
MFG. APPR.	DP	<b>RBW7110G00131-8G</b>	SHEET 11 OF 18
APPROVED	W	TITLE	SCALE
DATE 2/27/2019		REAR SLIDING COWLING LIFTING SLING TOOL	NTS
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ITEM #	QTY	PART #	PART TITLE
-11	1	RBW7110G00131-8G-11	JACKET
-12	1	RBW7110G00131-8G-12	FASTENER LOOP
-13	1	RBW7110G00131-8G-13	FASTENER HOOK



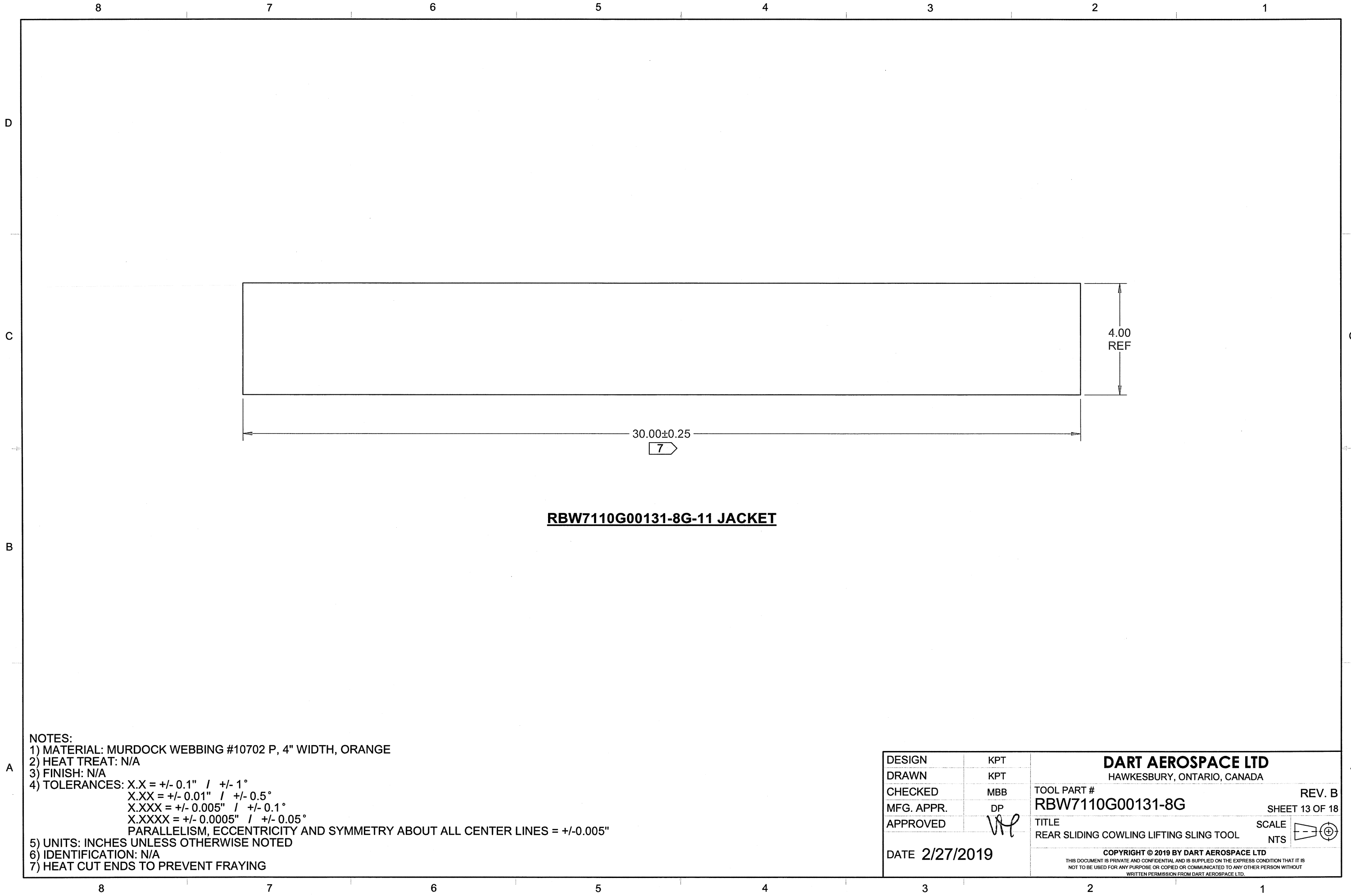
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**RBW7110G00131-8G-10 JACKET ASSEMBLY**

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

- NOTES:
- 1) MATERIAL: N/A
  - 2) HEAT TREAT: N/A
  - 3) FINISH: N/A
  - 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°  
X.XX = +/- 0.01" / +/- 0.5°  
X.XXX = +/- 0.005" / +/- 0.1°  
X.XXXX = +/- 0.0005" / +/- 0.05°  
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
  - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 6) IDENTIFICATION: N/A
  - 7) SEW ITEMS TOGETHER AS SHOWN
  - 8) STITCHING TO BE IAW ASTM D6193, TYPE 301, 6-10 STITCHES PER INCH, MINIMUM (1/2IN) BACKSTITCH, (1/2IN) SEAM ALLOWANCE, (1/2IN) TURNBACKS WHERE SHOWN, (1/8IN) FROM EDGE, ADDITIONAL ROWS OF SEWING ARE ACCEPTABLE TO ASSIST IN ASSEMBLY
  - 9) PHANTOM LINES REPRESENT STITCHING
  - 10) FASTENER LOOP/HOOK MUST BE ALIGNED WITH END OF JACKET BEFORE SEWING

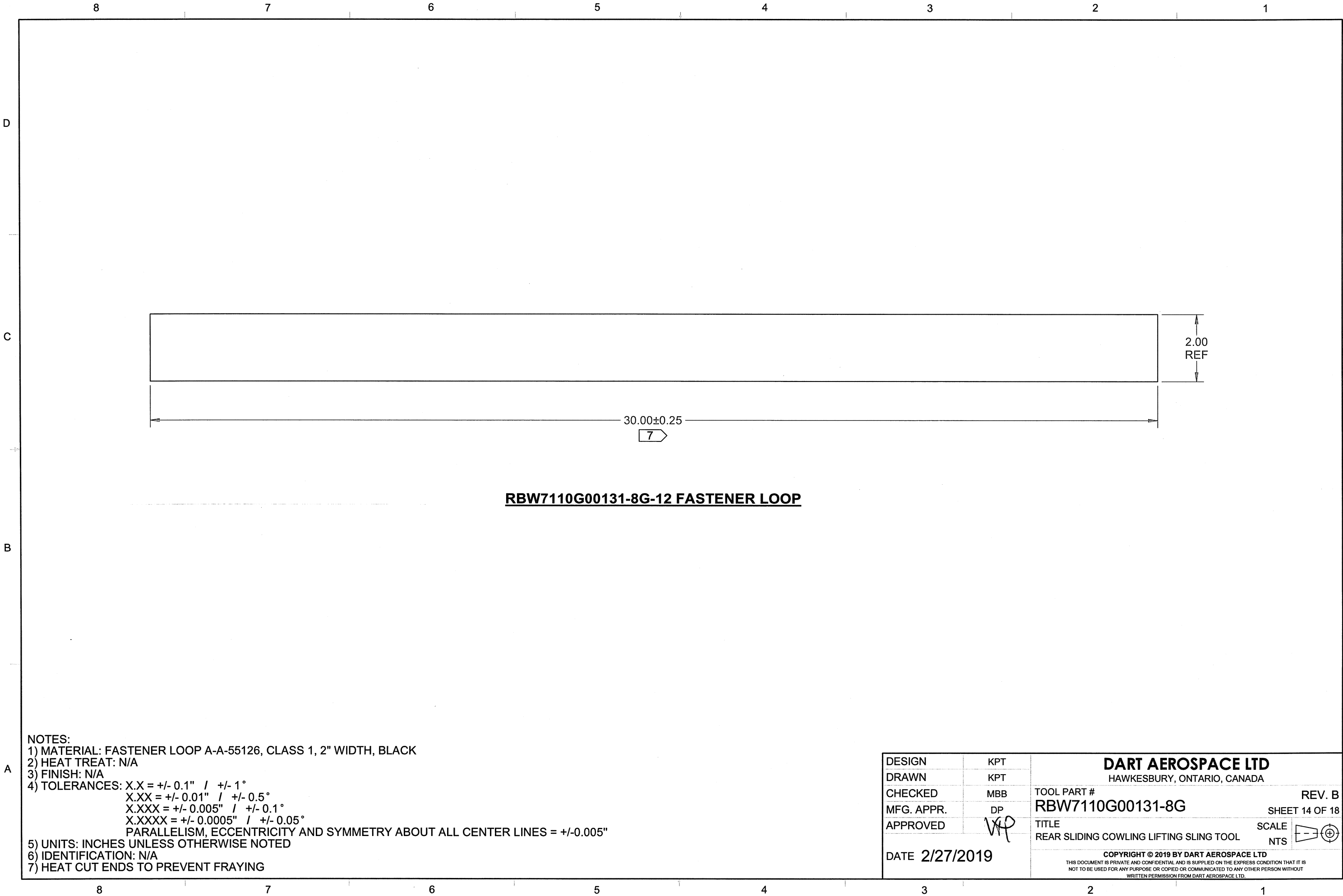
DESIGN	KPT	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	KPT		
CHECKED	MBB	TOOL PART #	REV. B
MFG. APPR.	DP	RBW7110G00131-8G	SHEET 12 OF 18
APPROVED		TITLE	SCALE
DATE 2/27/2019		REAR SLIDING COWLING LIFTING SLING TOOL	NTS
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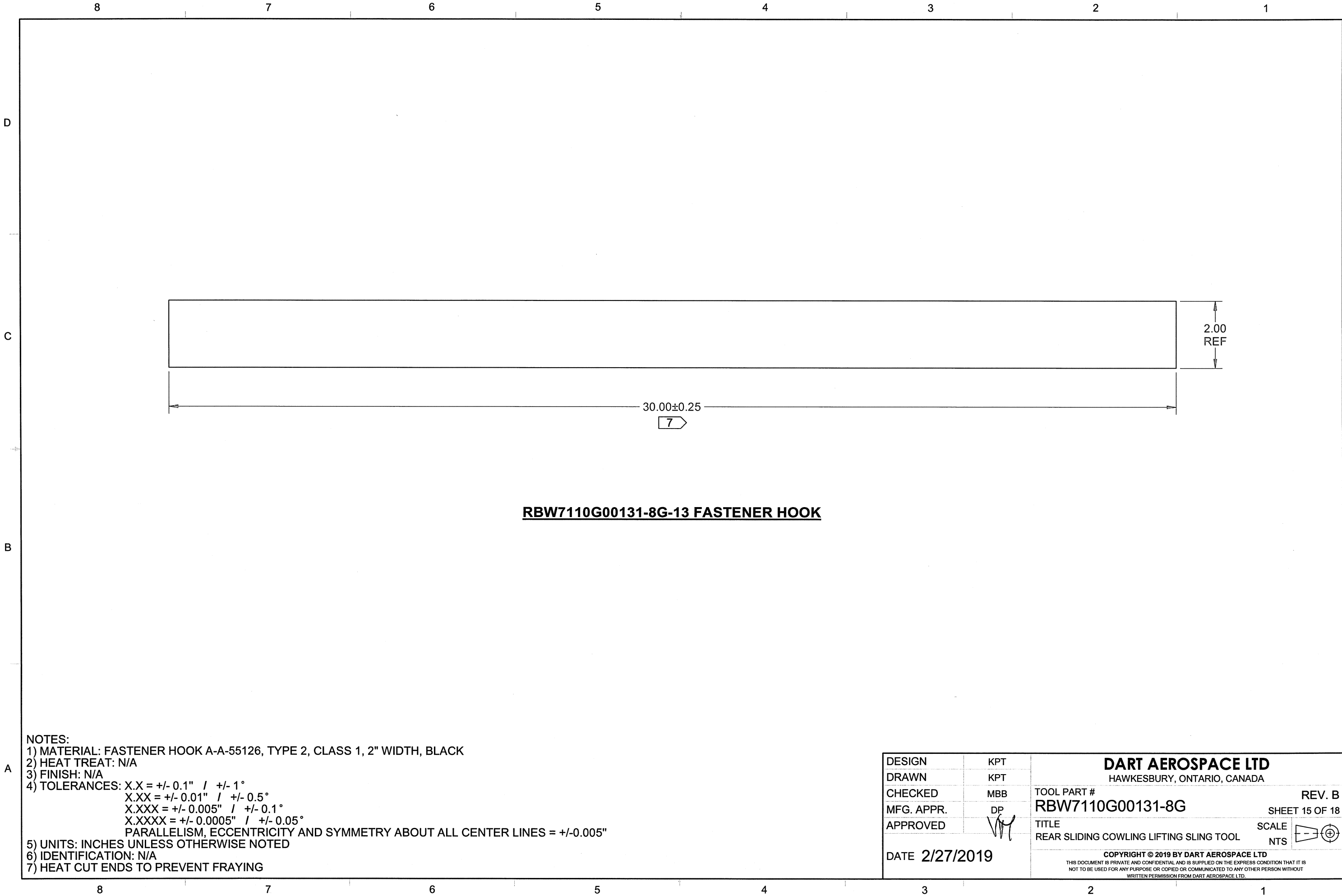


**RBW7110G00131-8G-11 JACKET**

NOTES:  
1) MATERIAL: MURDOCK WEBBING #10702 P, 4" WIDTH, ORANGE  
2) HEAT TREAT: N/A  
3) FINISH: N/A  
4) TOLERANCES: X.X = +/- 0.1" / +/- 1°  
X.XX = +/- 0.01" / +/- 0.5°  
X.XXX = +/- 0.005" / +/- 0.1°  
X.XXXX = +/- 0.0005" / +/- 0.05°  
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"  
5) UNITS: INCHES UNLESS OTHERWISE NOTED  
6) IDENTIFICATION: N/A  
7) HEAT CUT ENDS TO PREVENT FRAYING

DESIGN	KPT	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	KPT		
CHECKED	MBB	TOOL PART #	REV. B
MFG. APPR.	DP	<b>RBW7110G00131-8G</b>	SHEET 13 OF 18
APPROVED		TITLE	SCALE
DATE <b>2/27/2019</b>		REAR SLIDING COWLING LIFTING SLING TOOL	NTS 
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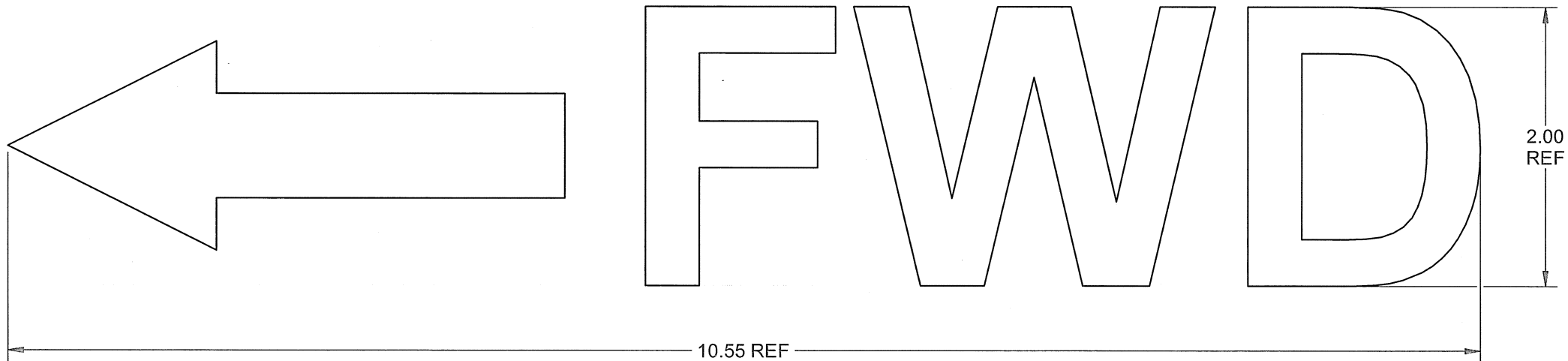
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



**RBW7110G00131-8G-14 FWD STICKER**

7

**NOTES:**

- 1) MATERIAL: 3M 7 MIL MASKING FILM #8522CP OR AVERY IPM #2031 OR EQUIV.  
2) HEAT TREAT: N/A  
3) FINISH: N/A  
4) TOLERANCES: X.X = +/- 0.1" / +/- 1°  
X.XX = +/- 0.01" / +/- 0.5°  
X.XXX = +/- 0.005" / +/- 0.1°  
X.XXXX = +/- 0.0005" / +/- 0.05°  
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"  
5) UNITS: INCHES UNLESS OTHERWISE NOTED  
6) IDENTIFICATION: N/A  
7) ALL NON-DIMENSIONED FEATURES MUST MAINTAIN A TOLERANCE OF +/- 0.050" PER CAD FILE RBW7110G00131-8G-14 REV. B.DXF

DESIGN	KPT	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	KPT		
CHECKED	MBB	TOOL PART #	REV. B
MFG. APPR.	DP	<b>RBW7110G00131-8G</b>	SHEET 16 OF 18
APPROVED		TITLE	SCALE
DATE <b>2/27/2019</b>		REAR SLIDING COWLING LIFTING SLING TOOL	NTS 
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1.00 REF  
MAXIMUM LOAD 40 KG  
14.94 REF

**RBW7110G00131-8G-15 MAX LOAD STICKER**

7

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NOTES:  
1) MATERIAL: 3M 7 MIL MASKING FILM #8522CP OR AVERY IPM #2031 OR EQUIV.  
2) HEAT TREAT: N/A  
3) FINISH: N/A  
4) TOLERANCES: X.X = +/- 0.1" / +/- 1°  
X.XX = +/- 0.01" / +/- 0.5°  
X.XXX = +/- 0.005" / +/- 0.1°  
X.XXXX = +/- 0.0005" / +/- 0.05°  
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"  
5) UNITS: INCHES UNLESS OTHERWISE NOTED  
6) IDENTIFICATION: N/A  
7) ALL NON-DIMENSIONED FEATURES MUST MAINTAIN A TOLERANCE OF +/- 0.050" PER CAD FILE RBW7110G00131-8G-15 REV. B.DXF

DESIGN	KPT	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	KPT		
CHECKED	MBB	TOOL PART #	REV. B
MFG. APPR.	DP	RBW7110G00131-8G	SHEET 17 OF 18
APPROVED	VP	TITLE	SCALE
DATE 2/27/2019		REAR SLIDING COWLING LIFTING SLING TOOL	NTS
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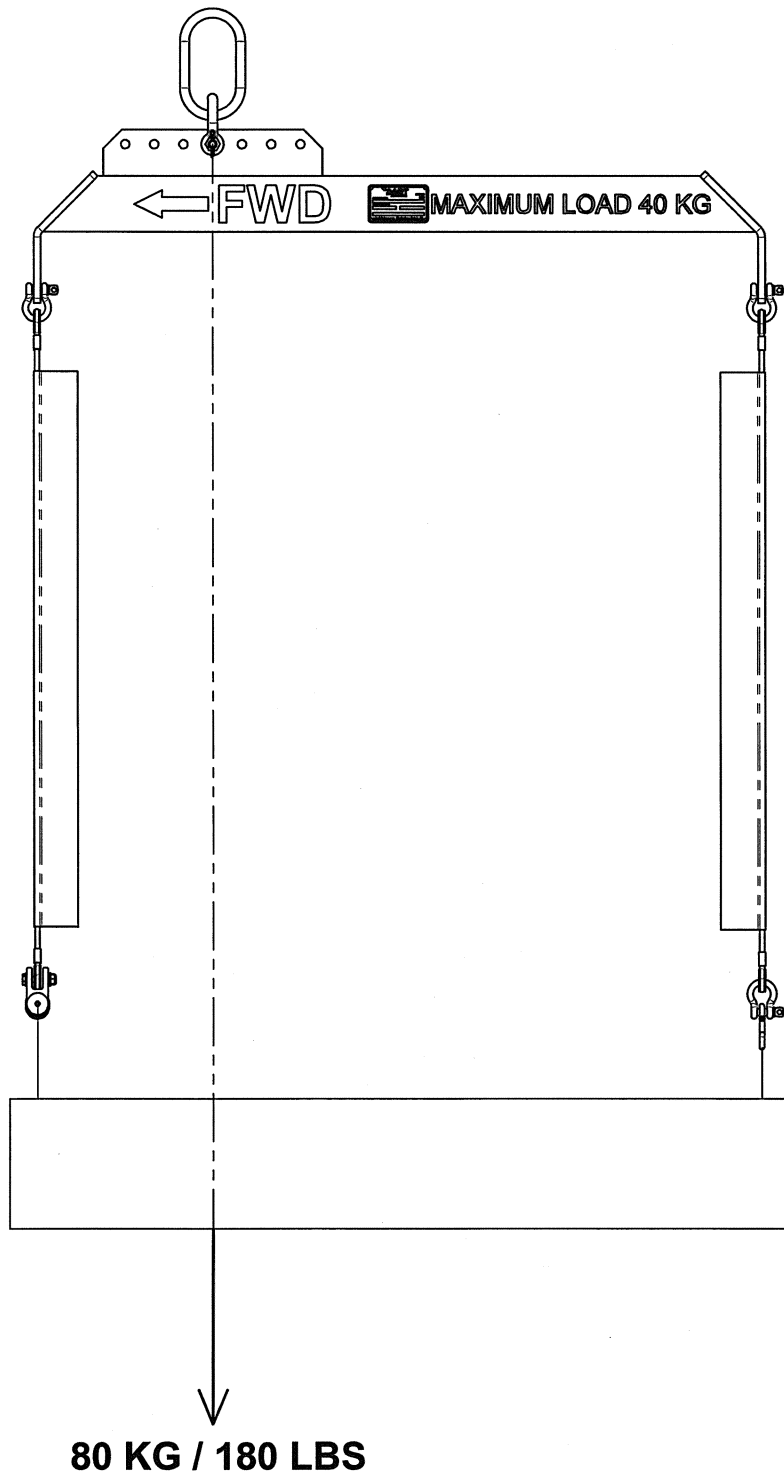
8 7 6 5 4 3 2 1

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FIRST ARTICLE WEIGHT TEST

1. AFTER INSPECTION, PLACE SLING ASSEMBLY ON AN OVERHEAD LIFTING DEVICE. ATTACH SLING TO AN APPROPRIATE TEST WEIGHT OF 80 KG / 180 LBS.
2. LIFT WEIGHT FOR AT LEAST 5 MINUTES, CONTINUALLY CHECKING FOR CRACKS, DEFLECTION, DISTORTION OR DAMAGED/FRAYED STRAPS.
3. REMOVE WEIGHT AND RE-INSPECT SLING, CHECKING FOR STRESS CRACKS, BENDING, DISTORTIONS OR DAMAGED/FRAYED STRAPS.

INSPECTOR: \_\_\_\_\_

TESTER: \_\_\_\_\_

S/N: \_\_\_\_\_


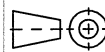
DATE: \_\_\_\_\_

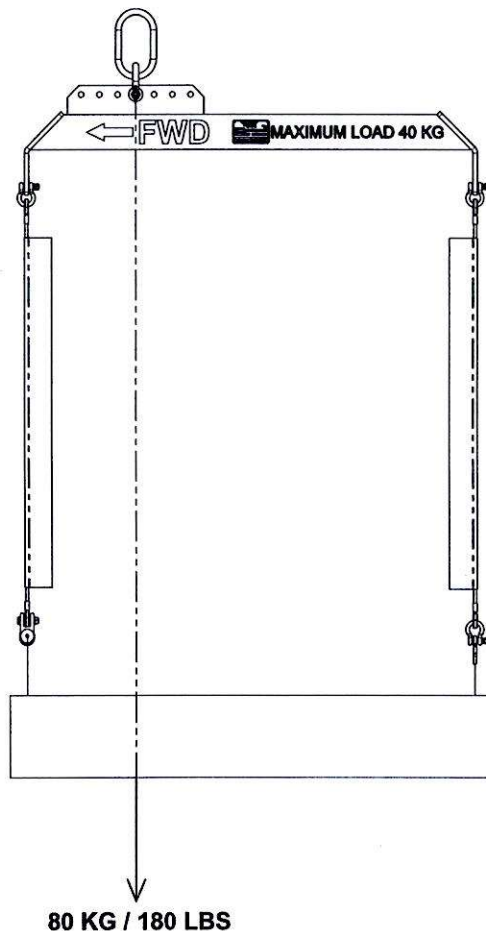
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DESIGN	KPT	<b>DART AEROSPACE LTD</b>	
DRAWN	KPT	HAWKESBURY, ONTARIO, CANADA	
CHECKED	MBB	TOOL PART #	REV. B
MFG. APPR.	DP	<b>RBW7110G00131-8G</b>	SHEET 18 OF 18
APPROVED		TITLE	SCALE
		REAR SLIDING COWLING LIFTING SLING TOOL	NTS 
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#### FIRST ARTICLE WEIGHT TEST

1. AFTER INSPECTION, PLACE SLING ASSEMBLY ON AN OVERHEAD LIFTING DEVICE. ATTACH SLING TO AN APPROPRIATE TEST WEIGHT OF 80 KG / 180 LBS.
2. LIFT WEIGHT FOR AT LEAST 5 MINUTES, CONTINUALLY CHECKING FOR CRACKS, DEFLECTION, DISTORTION OR DAMAGED/FRAYED STRAPS.
3. REMOVE WEIGHT AND RE-INSPECT SLING, CHECKING FOR STRESS CRACKS, BENDING, DISTORTIONS OR DAMAGED/FRAYED STRAPS.

INSPECTOR: DAS 68 FEB 04 2020  
 9-89  
 TESTER: ALAN PATRY  
 S/N: S252335  
 DATE: 2020-02-04

DESIGN	KPT	<b>DART AEROSPACE LTD</b>	
DRAWN	KPT	HAWKESBURY, ONTARIO, CANADA	
CHECKED	MBB	TOOL PART #	REV. B
MFG. APPR.	DP	RBW7110G00131-8G	SHEET 18 OF 18
APPROVED	<i>VP</i>	TITLE	SCALE
		REAR SLIDING COWLING LIFTING SLING TOOL	NTS
DATE	2/27/2019	<small>COPYRIGHT © 2019 BY DART AEROSPACE LTD          THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS          NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT          WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	